Date: User:

Thursday, 02/04/2009 2:18:51 PM

Julie Dawson

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 46904 : 10346 **Estimate Number**

P.O. Number

: 02/04/2009 This Issue

: NC

First Issue : //

: 46436 **Previous Run**

Written By

Prsht Rev.

Type : SKIDTUBES

S.O. No. :

Part Number

Drawing Name

: D2596

: D2596 REV D **Drawing Number**

: N/A : D

Project Number Drawing Revision

Material **Due Date**

: 09/04/2009

: 205 SKIDTUBE "I" BEAM

Qty:

6 Um:

Each

Comment

Checked & Approved By

: Est: D 99.02.02

Changed QA to QC, Added Step 6 and Cost D

М

Est Rev:E 07-07-09 Incorperated DEO 9183 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D25003100

Ext'n -`I' Beam Web 4"



Comment: Qty.:

1.0000 Each(s)/Unit

Total:

6.0000 Each(s)

Extrusion "I" Beam Web 4"

Pick;

Qty

Part Number

D2500-3-100

Description Extrusion

2.0

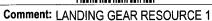
SKIDTUBES 1











- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596



39 -04 -62



3.0

HAND FINISHING1

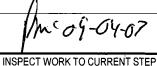


Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine per QSI 005 4.1



QC5



HAND FINISHING RESOURCE #1



4.0

Comment: INSPECT WORK TO CURRENT STEP







-

Page 1

Dart Aerospace Ltd

W/O: WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:	

Resolution:		esolution:	Disposition	1:	QA: N/C Clos	sed:	Date: _	···
NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCR)			
		Description of NC	Corrective Action Section B		Verification		A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:18:51 PM User: Julie Dawson **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: 205 SKIDTUBE "I" BEAM Job Number: 46904 Part Number: D2596 Job Number: Seq. #: **Machine Or Operation:** Description: 5.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock MB Location: 5Kid FINAL INSPECTION/W/O RELEASE 6.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aer	ospace	Ltd
-----------------	--------	-----

W/O:		WORK ORDER CHA	ANGES		·		
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		¥					
Part No		DAD #: Foult Cotogony	NOD. V.	No DO	A -	Data	

Part No:		_PAR #:	Fault Category:		NCR: Yes No	DQA:	Date:	
	Resolution:		Disposition:		QA: N/C Closed	:	Date:	
		\MC	DK OBDED NON	CONFORMAR	ICE (NCD)	· · · · · · · · · · · · · · · · · · ·		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
D.4.T.F		Description of NC		Corrective Action Section B			Annroyal	Annual			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
i											

NOTE: Date & initial all entries



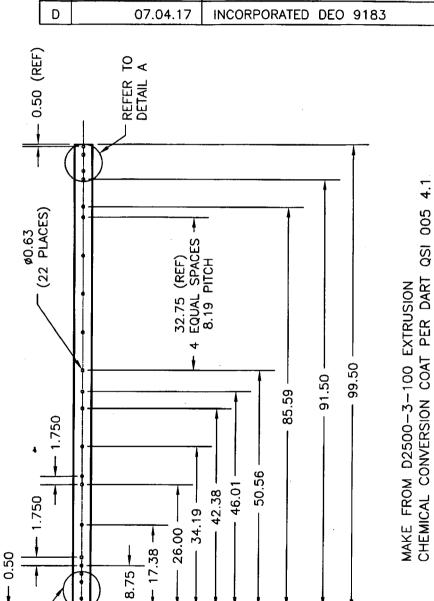
	DESIG	r PH	DRAWN BY	DART AEROSPACE LTE HAWKESBURY, ONTARIO, CANADA)
	CHEC	KED #11	APPROVED 1	DRAWING NO.	REV. D
ı		M	THE SHAPE	D2596 SHE	ET 1 OF 1
1	DATE			TITLE	SCALE
	07.0	04.17		205 WEB	1:20
	Α		96.09.16	NEW ISSUE	
	В		97.07.23	Ø0.63 HOLE WAS Ø0.56	
	С		98.09.14	INCORPORATED DEO 9097	

RELEASE 107 cc c8

3.500

1.750

REFER TO_



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEBURR SHARP EDGES 0.010 TO 0.020

ALL DIMENSIONS ARE IN INCHES

MATERIAL:

D2596 WEB

FINISH:

 $\frac{1}{2}$

SHOP COPY RETURN TO ENGINEERING

UNCONTROLLED COPY

TO AMENDMENT

6

Copyright © 1996 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart Aerospace Ltd

W/O:	-	WORK ORDER CHA	ANGES		****		,
DATE	STEP	STEP PROCEDURE CHANGE		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							•
						.,,	-

Part No:		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

	WORK ORDER NON-CONFORMANCE (NCR)									
	Description of NC		Corrective Action Section B	3	Varification	Annroyal				
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector			
					,					
	· ·									
	STEP	STEP Description of NC Section A	STEP Description of NC Section A Initial Chief Eng	STEP Description of NC Section A Initial Chief Eng Chi	STEP Description of NC Section A Chief Eng Chi	STEP Description of NC Section A Chief Eng Chi	STEP Description of NC Section A Initial Chief Eng Chief Eng Section B Section B Section C Secti			

NOTE: Date & initial all entries